

Work Order ID 52597

October 2, 2009 11:21:18 AM



Page 1

Item ID:	D3411-3	Accept		Setup	Start	
Revision ID:	REVA				Stop	
Item Name:	WASHER					
Start Date:	02/10/2009	Start Qty:	40.00	Cust Item ID:		
Required Date:	16/10/2009	Req'd Qty:	40.00	Customer:		

Reference:

Approvals:	Process Plan:	<i>BS</i>	Date:	09-10-2	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr

100		0.00	<i>SA 09/10/10</i>	<i>40</i>	<i>0</i>
		0.00			
Hardinge	Memo				
Hardinge CNC Lathe Small	Turn as per Folio FA591 Rev: <i>U/A</i> & Dwg D3411 Rev: <i>A</i>				
	Deburr & Tumble as per Dwg D3411				

110	QC2- Inspect parts off machine FAI/FAIB	0.00	<i>SA 09/10/10</i>	<i>40</i>	<i>0</i>
		0.00			
QC	Memo				
Quality Control					

120	QC8- Inspect parts - second check	0.00	<i>amf 09/10/11</i>	<i>40</i>	<i>0</i>
		0.00			
QC	Memo				
Quality Control					

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Item ID: D3411-3

Accept



Setup Start



Revision ID: REVA

Stop



Item Name: WASHER

Start Date: 02/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 16/10/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 90

0.00



Packaging

Memo

0.00

Packaging

P 09/12/13 (43) (cust) sp

140

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/14 JZ
09-10-13

Picklist Print

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Work Order ID: 52597



Parent Item: D3411-3RevREVA



Parent Item Name: WASHER

Start Date: 02/10/2009

Required Date: 16/10/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MDELRINR1.000		Purchased	No			100	f	53.9037	0.5726			
Delrin Round Bar 1"												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

53.90368421

108757

28.5736842

108804

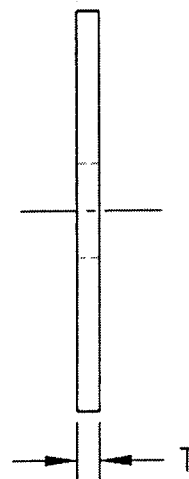
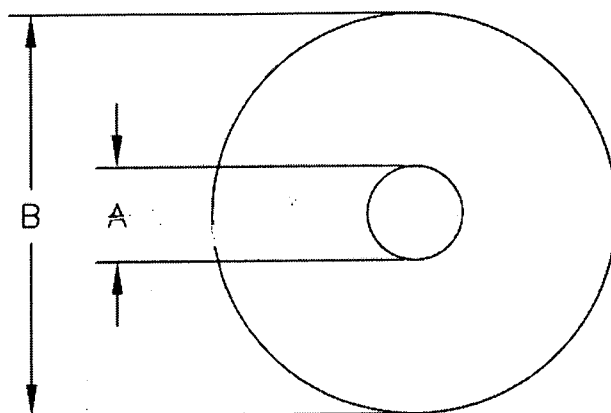
25.33

.57 SN 09/10/10



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3411	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE WASHER, DELRIN	SCALE NTS
A	05.03.16	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52597

[Signature] 09-10-2

1) SPECIFICATION: **D3411-X WASHER**

DASH No.

RELEASED
05.09.06 *[Signature]*

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH NO.	BOLT SIZE	A (in)	B (in)	T (in) ±0.006	NON-METALLIC REPLACEMENT FOR:
-3	#10	0.203	0.875	0.063	AN970-3
-4	1/4	0.265	1.125	0.063	AN970-4
-5	5/16	0.328	1.375	0.063	AN970-5
-6	3/8	0.390	1.625	0.063	AN970-6
-7	7/16	0.453	1.812	0.109	AN970-7
-8	1/2	0.515	2.000	0.109	AN970-8

- 2) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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